



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3488-042
Job Sheet 186673



Part No: D3488-042

Job Qty: 4 pcs

Part Name: Blade Fitting RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSK 101 REV D, D3488 REV C IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD IPP REV:D 18.11.09 AS PER DWG REV:C DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	4 pcs		12/7/18	0.00	3.52	Doosan - 1		
110	QC 2	4 pcs		12/7/18	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		



Container No: S147789



Part: D3488 - 042

Job No: 186673

Serial No/Batch: S147789

Revision: D/C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/24/19

DS

120	HAAS 4 Axis - B4B	4 pcs	12/7/18	0.11 2.74	QC 2 - 63	
					QC 2 - 8	
					HAAS - 1 - B4B	
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
130	QC 2	4 pcs	12/7/18	0.00 0.00	HAAS - 4 - B4B	2019/01/31
					QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	2019/01/31
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 38	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
140	QC 8	4 pcs	12/7/18	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	2019/02/01
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
150	Handfinish - 1-1 Chemical-B4B	4 pcs	12/7/18	0.00 0.12	QC 8 - 1 (A)	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	

[illegible]

						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
190 QC 5	4 pcs	12/7/18	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 38	
						QC 5 - 42	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	PD 19-02-08
						QC 5 - 50	
						QC 5 - 30	
200 Packaging 3-1 - Stock - B4B	4 pcs	12/7/18	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	FP-001 3/19-2-01
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA627 & Dwg D3488 130 - QC2- Inspect parts off machine FAI/FAIB 140 - QC8- Inspect parts - second check 150 - Chemical Conversion Coat per QSI005 4.1 1138997 160 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 3:15 OVEN TEMPERATURE: 320° FINISH TIME: 3:45 170 - QC3- Inspect Part Finish 180 - Install Inserts as per Dwg D3488 190 - QC5- Inspect part completeness to step on W/O 200 - Identify as per dwg & Stock Location: LOCATION : FP001 210 - QC21- Final Inspection - Work Order Release					FEB 08 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6103-003	Round Billet, Aluminum	4 pcs (1 ea)	100-Doosan - 1		
ALS7-1032-225	Insert	16 Ea (4 ea)	180-Handfinish - 4-1-Assembly-B4B	5038208	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6103-003	4	33	0	
180-Handfinish - 4-1-Assembly-B4B	ALS7-1032-225	16	451	0	
Part Specifications					
Specifications could not be found.					



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/7/18	0.00	0.00	Start Up Machining-2		
100	Doosan	4 pcs		12/7/18	0.00	3.52	Doosan		
110	QC	4 pcs		12/7/18	0.00	0.00	QC2 Machining-2		
120	CNC Vertical Machining	4 pcs		12/7/18	0.11	2.74	HAAS1-3		
130	QC	4 pcs		12/7/18	0.00	0.00	QC2 Machining-2		
140	QC	4 pcs		12/7/18	0.00	0.00	QC8 Machining-2		
150	HandFinish	4 pcs		12/7/18	0.00	0.12	HandFinish1		
160	Powdercoat	4 pcs		12/7/18	0.00	0.14	Powdercoat1		
170	QC	4 pcs		12/7/18	0.00	0.00	QC3		
180	HandFinish	4 pcs		12/7/18	0.00	0.00	HandFinish4		
190	QC	4 pcs		12/7/18	0.00	0.00	QC5		
200	Packaging	4 pcs		12/7/18	0.00	0.00	Packaging3-1		
210	QC21-SA	4 Ea		12/7/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

180 - Install Inserts as per Dwg D3488

200 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	4 Ea (1 ea)	90-Start up Operation	
ALS7-1032-225	Insert	16 Ea (4 ea)	180-HandFinish	5038208

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	4	23	0
180-HandFinish	ALS7-1032-225	16	888	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Specifications could not be found.

Plex 11/20/18 8:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DART AEROSPACE LTD		Work Order: 186673
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-2
Inspection Dwg: D3488 / DSK101		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.152				
Ø2.780	+/-0.005	2.779				
Ø3.125	+/-0.010	3.123				
Ø3.346	+/-0.010	3.350				
0.125 x 45°	+/-0.010 x +/-0.1°	0.120 x 45°				
8.000	+0.030/-0.000	8.010				
9.250	+/-0.010	9.251				
0.188	+/-0.010	0.188				
R0.032	+/-0.010	R0.032				
R0.062	+/-0.010	R0.062				
Ø0.297	+0.005/-0.001	0.300				
Ø0.430	+/-0.010	0.433				
0.100	+/-0.010	0.103				
0.125	+/-0.010	0.197				
2.620	+/-0.010	2.618				
3.500	+/-0.010	3.5				
1.005	+/-0.010	1.006				
Ø0.484	+0.005/-0.001	0.486				
1.180	+/-0.010	1.178				
3.150	+/-0.010	3.149				
3.070	+/-0.010	3.066				
R0.063	+/-0.010	R0.063				

DART AEROSPACE LTD		Work Order:	186673
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101		Rev: B / D	Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓		Vern M-08	
0.750	+/-0.010	.750	✓		"	
1.500	+/-0.010	1.500	✓		"	
11.18	+/-0.030	11.180	✓		"	
R0.062	+/-0.010	R.062	✓		R-6	
0.125	+/-0.010	.132			Vern M-08	
0.590	+/-0.010					
0.793	+/-0.010	.799	✓		"	
1.351	+/-0.010	1.351	✓		"	
1.317	+/-0.010	1.318	✓		"	
1.802	+/-0.010	1.800	✓		"	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	19/01/31	Date:	19/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	<i>[Signature]</i>